

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007483**Date Inspected:** 30-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 6/30/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2W1 - This Deviation saddle is currently in Fabrication Shop #4 awaiting PWHT MT inspection. All welds have been blasted to provide the best condition for the inspection. As this QA Inspector observed its current condition he noted the side of ID of the saddle section and confirmed by drawing it appeared incorrect.

Immediately, the QA Inspector contacted JSW representative Mr. H.Kon of the oversight. It was agreed, by Mr. Kon, and that they are preparing a list of all saddles and the resultant effect the stamp irregularity has on each saddle as well as the traceability of each.

W2W2 - QA Inspector observed this saddle remaining under heat to maintain preheat as it is welded to its plate build up section. No welding intended this afternoon/evening of 6/30/09, Mr Chung Fu Kuan informed this QA inspector of the possibility of C shift performing weld to this saddle.

W2W3 - Mr. D.Kito 08-5175 is in process of buttering per SJ-3012-1-2 the locations inside the trough that will accommodate the anti-distortion "stay bars". The procedure reflects the process and controls in use, such as SMAW, E7016 5mm electrode. These parameters were monitored by both QC CWI's Mr. Chung Fu Kuan and Mr. Pin-Tang Hsu.

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TOWER SADDLES

T1-2 - Welders T.Sudo 03-3082 and M.Yamashita 73-4195 were actively welding repairs to weld joints 8Y-5U-3 and -4 respectively. Process was SMAW 5mm E7016 electrode. Parameters set forth by procedure SJ-3012-6 were monitored by QC CWI Mr. Chung Fu Kuan.

T1-3 - Groove preparation for this saddle section to be fit up to its base plate is completed, now, Mr. M.Sato #81 of NIS QC inspection team, is performing dry powder MT of all bevels to confirm no laminations are present before fit up.

EAST SADDLES

E2E1 - ECS on casting repairs has been drafted and released for approval, cast awaits weld repair in Foundry. Splay plate cover has been sent out for Post Weld Heat Treat.

E2W1 - Casting has had weld repair reinforcements carbon arc'd followed by mechanical grinding and now sits idle in Foundry.

West Jacking Saddle - Cast Section has completed carbon arc shaping in the Foundry, next, it will undergo a mechanical dressing of carbon arc'd surface condition.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
